

RE-Print

Work Order ID 134748

134748

Page 1

Thursday, March 10, 2016 7:38:14 AM

Item ID: D2011-101 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mirror 6"
 Start Date: 7/17/2015 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 7/24/2015 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2011	Rev G								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.60							
Purchasing	Issue P/O: 29191 Mirror P/N: CHM10601 Possible supplier: Auto Parts ExtraMaterial release note required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

SCRAP

12 MAR 10 2016 DAS 13 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: RDH Date: 16/07/04Work Order update only ☐

Work Order: <u>134748</u> Part No. <u>D 2011-101</u> NCR No. <u>16-5879</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☒</td> <td>Other ☒ <u>Purchasing</u></td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☒	Other ☒ <u>Purchasing</u>	Large Fab ☐	Composite ☐	Supplier ☐																																																	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																				
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																				
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☒	Other ☒ <u>Purchasing</u>																																																																				
Large Fab ☐	Composite ☐	Supplier ☐																																																																					
Date: <u>16-03-10</u>		Step #: <u>100</u>		QTY Effective: <u>12</u>		MRB (QSI042) Approval <u>9</u> <u>9-89</u> <u>16-03-10</u>																																																																	
Description Work Order Deviation				Disposition																																																																			
Part was ordered from old supplier (Benson auto part) and with no CoFC Parts are now ordered by BC industrial.				Scrap + destroy.				Completed By <u>DAS</u> <u>30</u> <u>9-89</u> JUN 08 2010																																																															
								Lead hand / Supervisor <u>9</u> <u>9-89</u> <u>16-06-14</u>																																																															
								QC / QA Coordinator <u>PD</u> <u>16-08-10</u>																																																															
								Approval Verification <u>9</u> <u>9-89</u>																																																															
Root Cause <table style="width:100%;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>☒ Poor Information</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	☒ Poor Information	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td>Pressure/Forced ☐</td> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☒</td> <td>Part Incorrect ☒</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>						Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☒	Part Incorrect ☒	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐																																																																						
Design ☐	Operator ☐																																																																						
Doc/Data ☐	Offset/Setup ☐																																																																						
Equip/Tooling ☐	Supplier ☐																																																																						
Handling/Pre ☐	Training ☐																																																																						
Material ☐	Use for Testing ☐																																																																						
Internal Transport ☐	☒ Poor Information																																																																						
Tribal Knowledge ☐	Rushing ☐																																																																						
LOA ☐	Product Improvement ☐																																																																						
Substation ☐	Process Improvement ☐																																																																						
Past Expiry Date ☐	Manufacturing Process ☐																																																																						
Misidentified ☐	Past Due ☐																																																																						
Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																				
Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																				
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																				
Cracks ☐	Broken/Damage/Defect ☐	Weld ☒	Part Incorrect ☒																																																																				
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																				
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																				
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																				
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																				
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																				
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																				
OTHER: _____																																																																							

Work Order ID 134748***134748***

Page 3

Thursday, March 10, 2016 7:38:14 AM

Item ID: D2011-101 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mirror 6"
Start Date: 7/17/2015 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 7/24/2015 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.02							
Quality Control									

MCS JUN 10 2016
φ

Picklist Print

Page 1

Thursday, March 10, 2016 7:38:13 AM

Work Order ID: 134748

134748

Parent Item: D2011-101

D2011-101

Parent Item Name: Mirror 6"

Start Date: 7/17/2015

Required Date: 7/24/2015

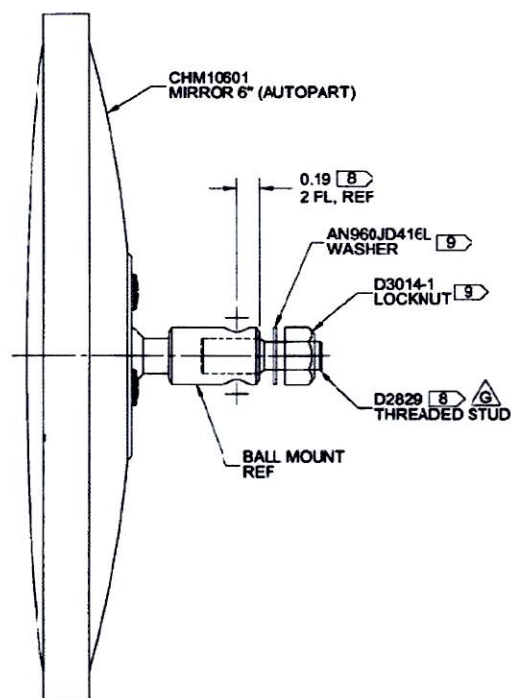
Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: J04.09.15Added Steps 5-7 KJ/JLM IPP:
K05.12.15chg black sika flex for white EC IPP L 08.11.06 new
drawing EC verify: DD IPP: M 08.12.19 Added step 3 KJ Verified
by: LL IPP rev N 10.01.13 added wrap per ncr09-118 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2829		Manufactured	No			130	Each	45.0000	1	12			
D2829									**				
Threaded Stud													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				45					
					122346			45					
D3014-1		Manufactured	No			130	Each	170.0000	1	12			
D3014-1									**				
Lock Nut													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST015				170					
					122272			170					
NAS1149D0416J		Purchased	No			110	Each	4,304.000	1	12			
NAS1149D0416.J									**				
WASHER													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				256					
					m131511			256					
				ST260a				1986					
					m131511			1986					
				ST264				2062					
					m131511			2062					

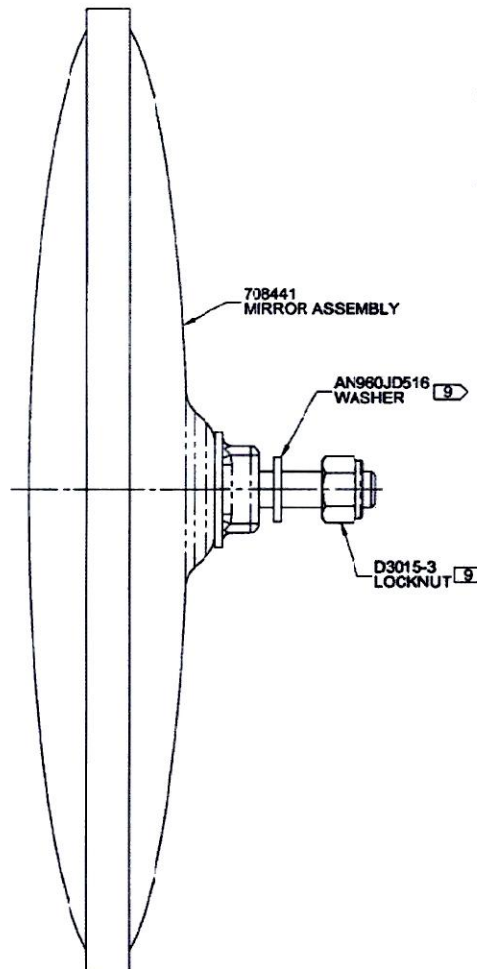
8 7 6 5 4 3 2 1



D2011-101 MIRROR ASSEMBLY 6"

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2011-101 = 0.6 lbs APPROX. ; D2011-103 = 1.0 lbs APPROX.
- 8) D2829 INSTALLATION PROCEDURE:
 - APPLY LOCKTITE 262 TO Ø 5/16 END OF D2829
 - THREAD BY HAND INTO BALL MOUNT UNTIL ENTIRE Ø 5/16 END OF D2829 IS WITHIN BALL MOUNT
 - CRIMP BALL MOUNT ON TWO OPPOSING SIDES, 0.13 FROM END AS ILLUSTRATED USING TOOL DT8317
 - CRIMP TO DEPTH OF 0.040 ± 0.010 USING R0.125
- 9) INSTALL LOOSE



D2011-103 MIRROR ASSEMBLY 8"

ITEM	QTY -101	QTY -103	P/N	DESCRIPTION
1	X		D2011-101	MIRROR ASSEMBLY 6"
2		X	D2011-103	MIRROR ASSEMBLY 8"
3	1		D2829	THREADED STUD
4	1		D3014-1	LOCKNUT
5		1	D3015-3	LOCKNUT
6	1		CHM10601	MIRROR 6" (AUTOPART)
7		1	708441	MIRROR 8" (VELVAC)
8	1		AN960JD416L	WASHER
9		1	AN960JD516	WASHER

Handwritten: CX MAR 10 2016 WID 134748

RELEASED
08-10-29/11

G	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT; MIRROR 6" (AUTOPART) AND CHM10601 WERE MIRROR 6" (GROTE) AND PIN 28043 (ZN D3-1); ADDED D2829 (ZN D3-1 AND ZN D3-1); REMOVED DRILLING NOTE, VIEW A-A AND SIKAFLEX APPLICATION NOTE; REASON: GROTE PRODUCT IS DISCONTINUED	MB	08-10-06
F	ADD HOLES FOR SEALANT ON -101	CP	04.09.10
E	NEW 8" MIRROR	CP	01.05.08
D	NEW 6" MIRROR, ADD NUT, REMOVED STUD	CP	01.04.23
C	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	RF	99.06.01
B	SIKAFLEX 241 ADDED	JB	98.04.09
A	DWG NO. WAS DSP1011, ADDED -103	JB	90.06.15
-	NEW ISSUE	JB	90.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN			
CHECKED			
MFG. APPR			
APPROVED			
DE APPR			
DATE	08.10.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D2011
TITLE MIRROR ASSEMBLY
SCALE NTS

COPYRIGHT © 1990 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND NOT TO BE RELEASED OR DISCLOSED TO THE PUBLIC OR TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29191**

Purchase Order Date 7/20/2015

PO Print Date 3/10/2016

Page Number 1 of 1

Order From :

VC-AUT001

Ship To : DART AEROSPACE LTD

BENSON AUTO PARTS
1000 RUE LANSLOWNE
HAWKESBURY, ON K6A 1H7
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 632 1191

Ship To Contact

Ship To Phone

Ship Via: —

Ship Acct:

Buyer

Linda Lacelle

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	CHM-10601	Mirror 6"	7/23/2015 Yes 7/23/2015		12.00 Each	\$20.75	\$249.00
	PER DRWG D2011 REV. G						
						Line Total:	\$249.00
2	71401-45	Procurement Quality Clause	7/23/2015 No 7/23/2015		1.00	\$0.00	\$0.00
	PROCUREMENT QUALITY CLAUSES A005 RIGHT OF ENTRY A016 PERSONNEL QUALIFICATION A025 CERTIFICATE OF CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS						
						Line Total:	\$0.00
						PO Total:	\$249.00

REFERENCE ONLY

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 2

Change Date: 3/10/2016